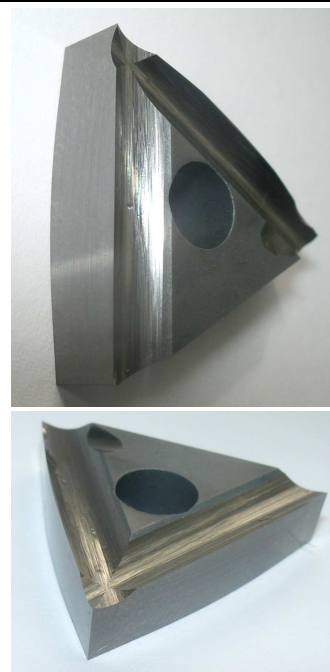










Triang.Insert, Profile R200

A08-200

The Profile has 1 degree clearance angle and can easily be ground with an 1A1 wheel in one setup with the chipbreakers



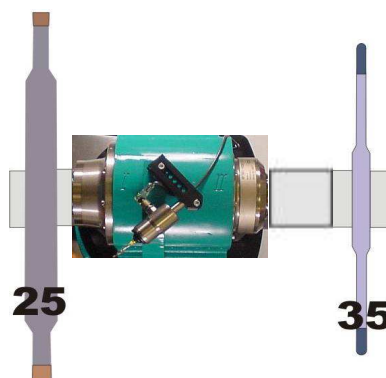
1. Cycletime for Production

Tool specifications InnerDiameter 15.85, Profile Radius 200 mm, 2 Chipbreakers R 5 Material CARBIDE					
Operations					
Probe					
Chipbreaker					
D.R200 Prep					
O.D.R200 Fin					
Unload					
Feed [mm/Min]	2000	80	35	60	9000
Power [kW]		1	1	2	1
Cutting feed [m/s]		18	22	22	
Used wheels					
Grinding time [s]	5	108	71	60	16
Total cycle time	4 Min 19				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

35	14F1 Ø150 D76
25	1A1 Ø300 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

responsible engineer: OP,31.10.08

www.schneeberger.ch

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